

Work Order ID 82612

April-03-12 11:30:17 AM

82612

Page 1

Item ID: D3589-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AFT GUIDE PLATE
 Start Date: 03/04/2012 Start Qty: 7.00 ***7*** Cust Item ID:
 Required Date: 17/04/2012 Req'd Qty: 7.00 ***7*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/03 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3589	Rev B

100 0.00
100
 Waterjet
 FLOW CNC Waterjet
 304 - 063
 Memo
 Cut as per dwg D3589
 Prog Rev: 8
 Dwg Rev: 8
 Deburr as required
 0.00 B12-4-7
 (10)

110 0.00
110
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo
 0.00 B12-4-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82612

April-03-12 11:30:17 AM

82612

Page 2

Item ID: D3589-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AFT GUIDE PLATE

Start Date: 03/04/2012 Start Qty: 7.00

7

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

1- Form as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		82612 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3589-7 PAR #: Fault Category: Long FFB / wedge NCR: (Yes) No DQA: Ant Date: 12/04/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 12/4/16

NCR: 12-1351		WORK ORDER NON-CONFORMANCE (NCR) 4.7A						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/14	#	Part scrap due to front Bend. P.C. Process	S 12/04/14 057042	Scrap + Destroy no Reuse QH x1	EL 12-4/11	S 12/04/14	S 057042 12/04/14	S 12/04/14

NOTE: Date & initial all entries

Work Order ID 82612

82612

Page 3

April-03-12 11:30:17 AM

Item ID: D3589-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AFT GUIDE PLATE

Start Date: 03/04/2012 Start Qty: 7.00

7

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: SWA 0.00

150

Packaging

Memo

0.00

Packaging

9k

SP

12-04-12

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/4/12

12-04-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-03-12 11:30:20 AM

Page 1

Work Order ID: 82612

82612

Parent Item: D3589-7

D3589-7

Parent Item Name: AFT GUIDE PLATE

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-05 new issue DD verified by:ec
02-20 rev.b asper dwg DD verified by:EC
IPP Rev:B 09-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	261.7520	0.06	0.442105			

M304S16GA

304/316 Sheet .063

**

B12-4-7

(10)

Location

Loc Qty

Loc Code

MAT020

261.752

120866

39.946

120877

143.306

121070

78.5

120866

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

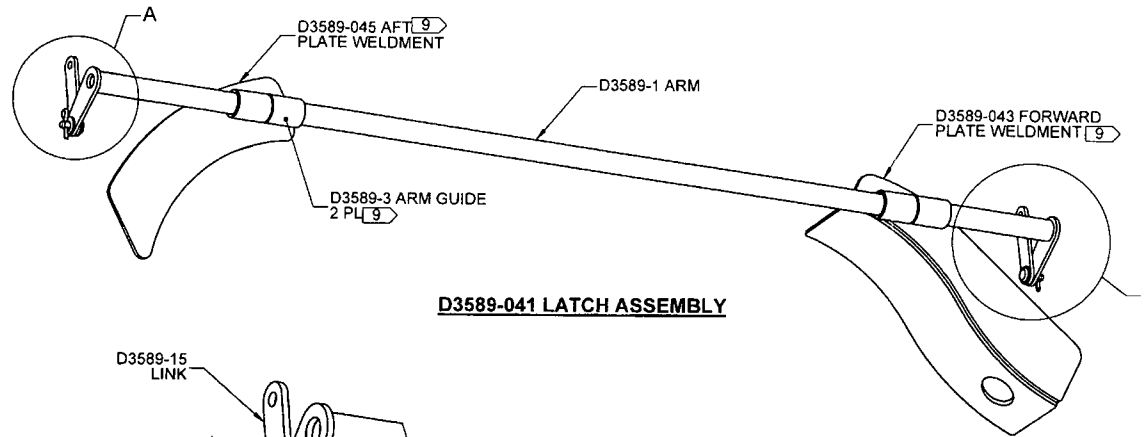
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

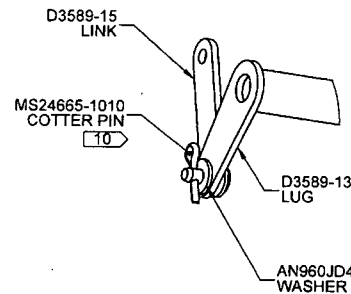
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

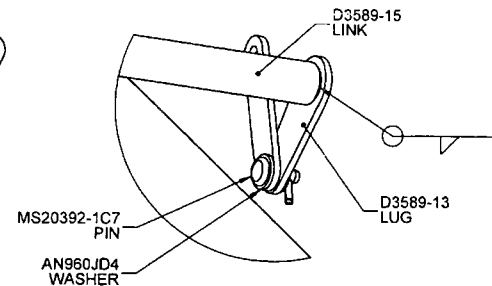
QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL
SCALE 2X
2 PL



**DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL**
SCALE 2X
2 PL

RELEASED
9/6/05 MLJ

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 82612 MLJ
12/04/03

D3589-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-8 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	JH		
DRAWN	JH		
CHECKED	PH		
MFG. APPR.	DS		
APPROVED	JH		
DE APPR.	JH		
DATE	08.06.25		

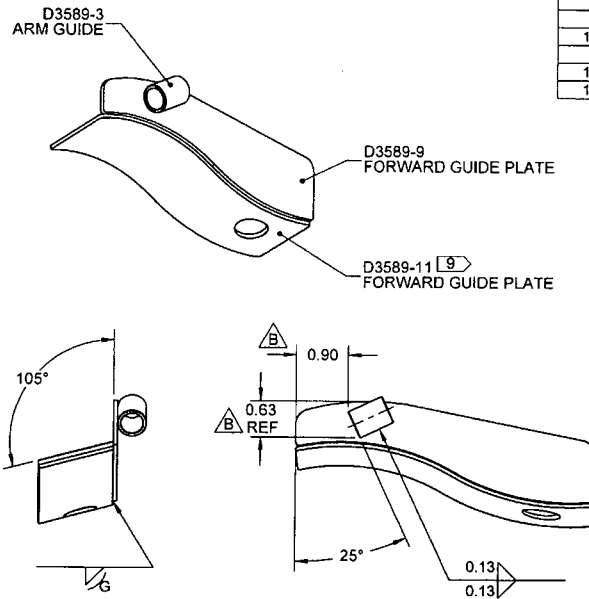
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3589** REV. B
SHEET 1 OF 8

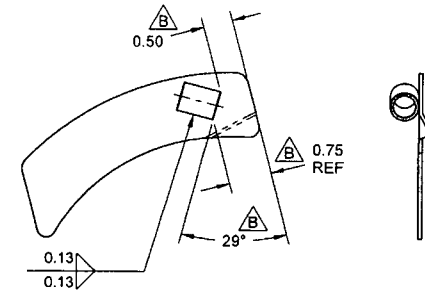
TITLE **LATCH ASSEMBLY** SCALE NTS

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QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/-045 NOTES:

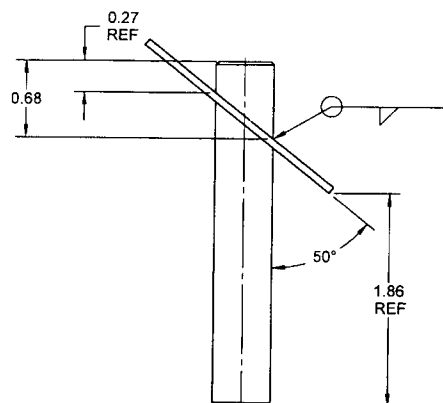
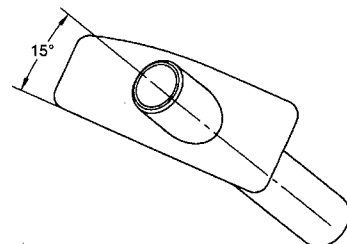
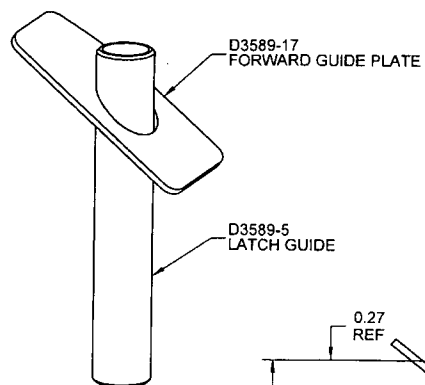
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3589 REV. B
MFG. APPR.		SHEET 2 OF 8
APPROVED		TITLE LATCH ASSEMBLY SCALE
DE APPR.		NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD

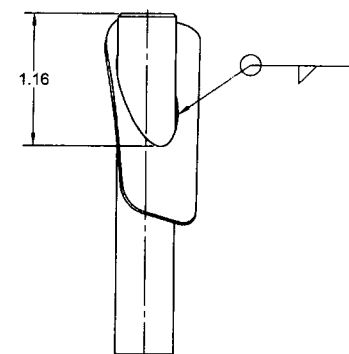
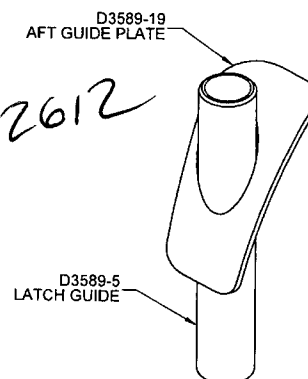
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RELEASED
09/02/05

QTY -047	QTY -049	P/N	DESCRIPTION
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE



D3589-047 FORWARD GUIDE



D3589-049 AFT GUIDE

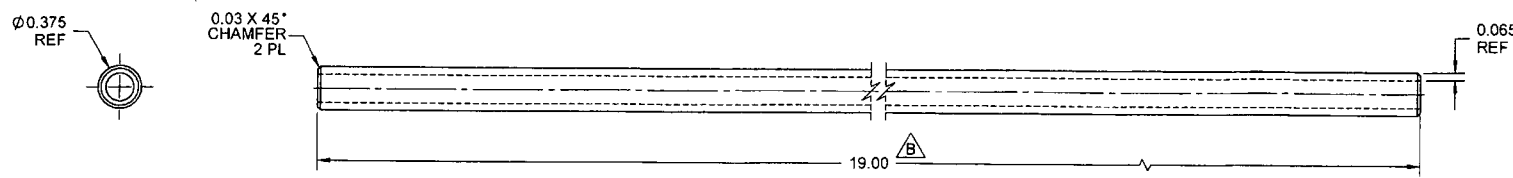
D3589-047/-049 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

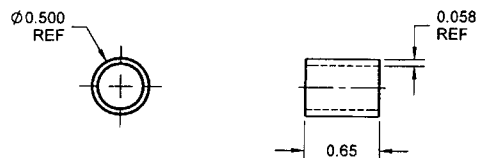
RELEASED
9/2/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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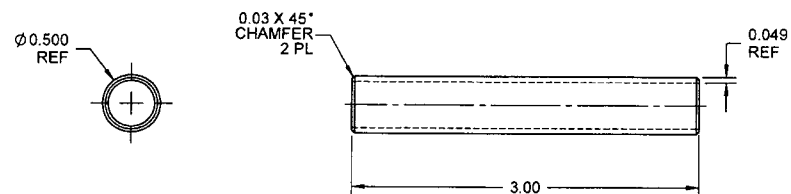
82012



D3589-1 ARM



D3589-3 ARM GUIDE



D3589-5 LATCH GUIDE

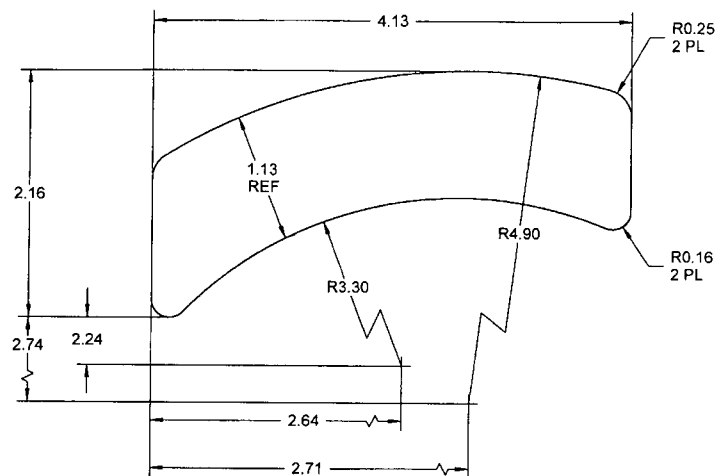
D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs

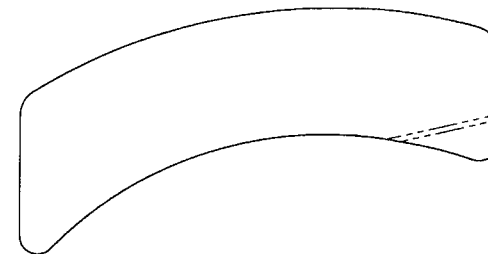
RELEASED
 09/02/05 MTS

DESIGN	JH	DART AEROSPACE LTD	
DRAWN	JH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3589	REV. B
MFG. APPR.	DS	SHEET 4 OF 8	
APPROVED	PH	TITLE LATCH ASSEMBLY	SCALE
DE APPR.	PH	NTS	
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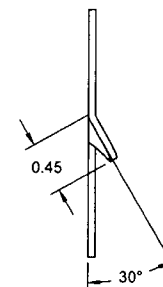
82612



**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F**

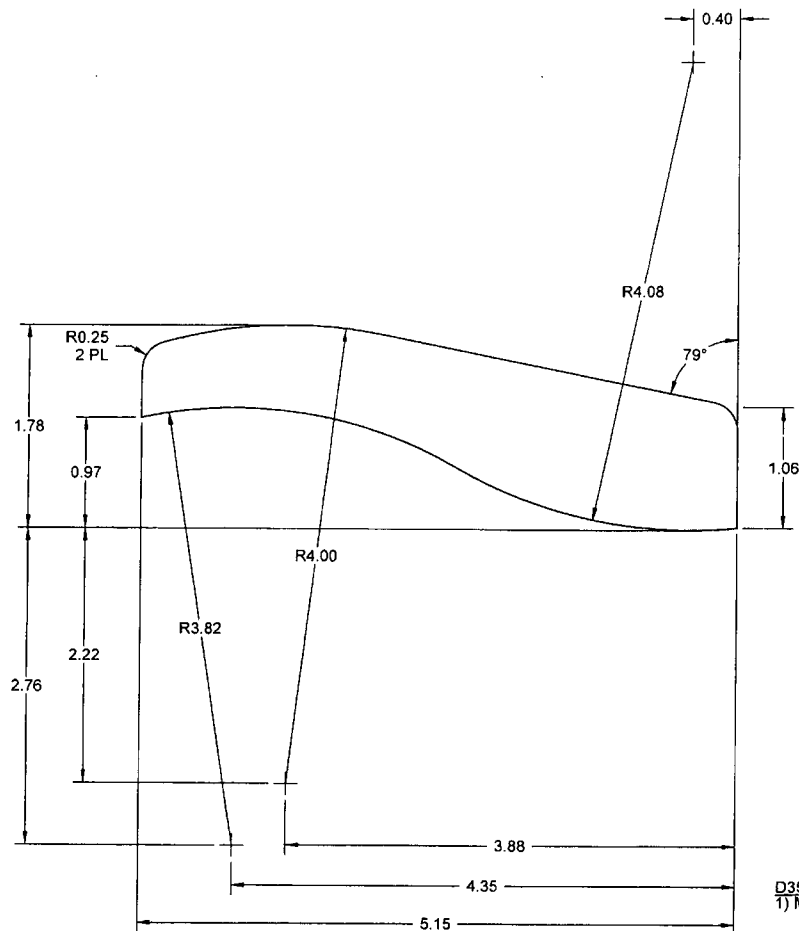


RELEASED
09/22/25

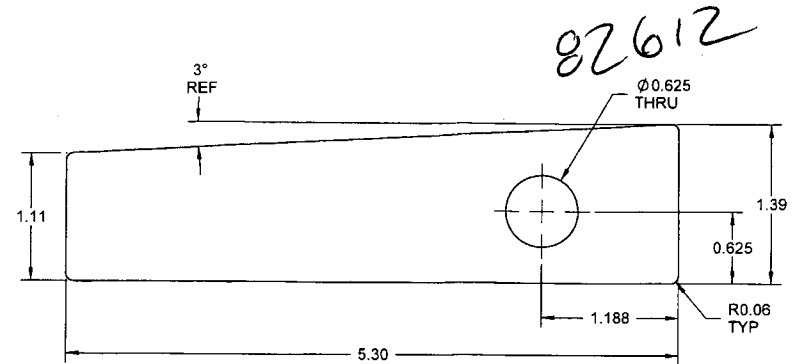
D3589-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

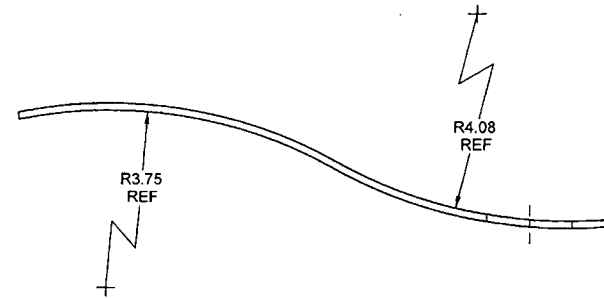
DESIGN	J	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CH	DRAWING NO. D3589	REV. B
MFG. APPR.	IS	SHEET 5 OF 8	
APPROVED	JP	TITLE LATCH ASSEMBLY	SCALE
DE APPR.	JH	NTS	
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D3589-9 FORWARD GUIDE PLATE









D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN



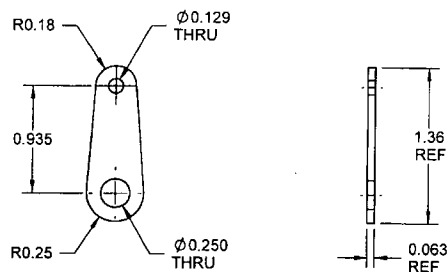
D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)

- D3589-9/-11/-11F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs EACH
 - 8) CONTROL SHAPE PER DT9021 TEMPLATE

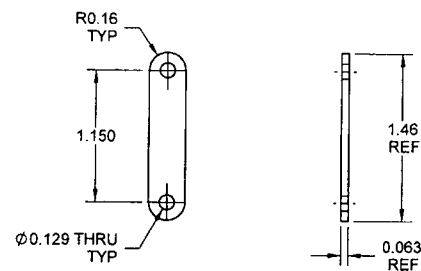
RELEASED
09/22/05/11/14

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FORWARD GUIDE PLATE	NTS
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826 12



D3589-13 LUG



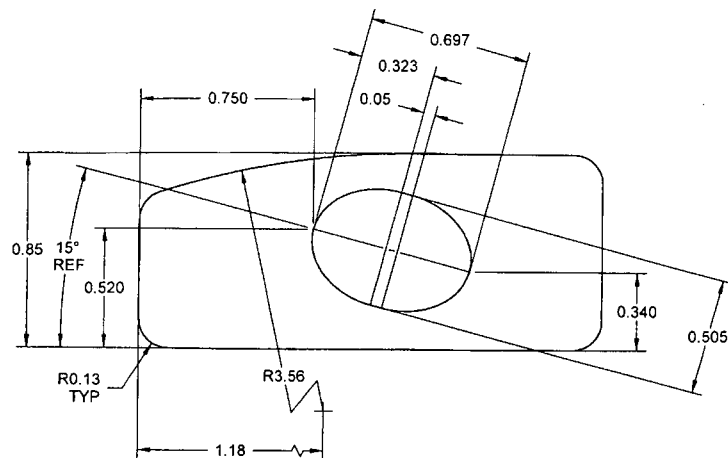
D3589-15 LINK

RELEASED
08/02/05 NTP

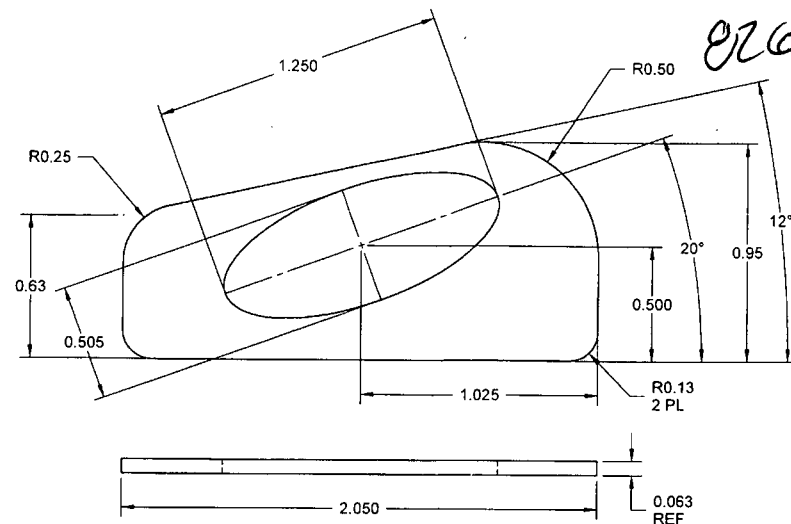
D3589-13/-15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

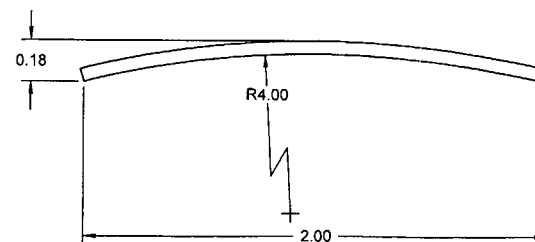
DESIGN	JH	DART AEROSPACE LTD	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3589	REV. B
MFG. APPR.	DS	SHEET 7 OF 8	
APPROVED	MD	TITLE LATCH ASSEMBLY	SCALE
DE APPR.	MT	NTS	
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D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)

RELEASED
09/02/05/118

D3589-17/-19/-19F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>[Signature]</i>			
CHECKED	<i>[Signature]</i>		DRAWING NO.	REV. <i>B</i>
MFG. APPR.	<i>[Signature]</i>		D3589	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>		TITLE	SCALE
DE APPR.	<i>[Signature]</i>		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD		
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